

Work Order ID 137342

137342

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Tuesday, September 29, 2015 8:12:53 AM

Item ID: D4471-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mid Rib Assembly, RH
 Start Date: 9/23/2015 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 9/23/2015 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 150929 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4471	B								

100 0.00
100
 Bandsaw Memo 0.00
 Jeaspa Bandsaw CUT BLANK 17" LONG
 DAS 14 9-89 15/09/29

110 0.00
110
 Purchasing Memo 0.00
 Purchasing ISSUE P/O: 29983
 TO ARCHUR PRESSION(GLOBUS)
 C OF C IS REQUIRED
 OCT 02 2015

120 0.00
120
 QC Memo 0.00
 Quality Control QC6- Inspect dimensions to drawing
 5x 50151104

5
 DAS 38 9-89
 NOV 05 2015

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Tuesday, September 29, 2015 8:12:53 AM

Item ID: D4471-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mid Rib Assembly, RH
Start Date: 9/23/2015 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 9/23/2015 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130						53	FF		NOV 09 2015
HandFinish	Memo	0.00							
Hand Finishing									
131	QC7-Inspect Chemical Conversion Coat	0.00							DAS 38 9-89
131						5			NOV 09 2015
QC	Memo	0.00							
Quality Control									
180		0.00							DAS 41 9-89
180						5			15-11-20
SprayPaint	Memo	0.00							
Spray Painting	Prime Tempo grey as per DART QSI 005 4.2								
	MASK ALL HOLES								
	132910								

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NS1

NS2

Customer:

NR1

NR2

**Insp.
Stamp**

DAS
38
9-89

NOV 23 2015

15/11/23 DAS 36 9-89

38
9-89

NOV 23 2015

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Adt Date: 15/12/09QA Closed: Qul Date: 15/12/10

Work Order: <u>137342</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D4471-042</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-5474</u>		Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☒	NOV 23 2015	191	5	20 rivets MS 20426 AD 3-4 Used instead of MS 20605 AD 3-5	DAS 22 9-89	ACCEPTABLE. NOT STRUCTURAL (REF. W104 96299).	[Signature] 15/11/23	DAS 30 9-89	DAS 38 9-89 NOV 23 2015
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General
☐ Bending	☐ Bend
☐ Centre Not Concentric to O/S	☐ BOM/Route
☐ Cracks	☐ Broken/Damaged
☐ Crushed/Crimped.	☐ Burrs
☐ Cuffs	☐ Contamination
☐ Heat Treat	☐ Countersink
☐ Inspection Strip in Tube	☐ Cut Too Short
☐ Ripples in Bend	☐ Drill Holes
☐ Torque Waves in Extrusion	☐ Drawing
☐ Turning Sequence	☐ Finish
☐ Wave/Twist in Tube	☐ Folio
	☐ Grain
	☐ Hardware
	☐ Inspection Incomplete
	☐ Instructions Incomplete/Unclear
	☐ Maintenance
	☐ Mislabelled
	☐ Misread
	☐ Offset
	☐ Out of Calibration
	☐ Out of Sequence
	☐ Outside Dimensions
	☐ Ovalized
	☐ Over/Under tolerance
	☐ Part Incorrect
	☐ Part Lost/Missing
	☐ Part Moved
	☐ Positioned Wrong
	☐ Power Loss/Surge
	☐ Pressure/Forced
	☐ Temperature/Cure
	☐ Weld
	☒ Wrong Stock Pulled
	☐ Other

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Item ID: D4471-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mid Rib Assembly, RH
Start Date: 9/23/2015 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 9/23/2015 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>St 227B</u>	0.00							
200									
Packaging	Memo	0.00				5	D46		
Packaging							6		
							3-50		NOV 24 2015
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

ML5 15-11-25

ML5 15-11-24

Picklist Print

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Work Order ID: 137342

137342

Parent Item: D4471-042

D4471-042

Parent Item Name: Mid Rib Assembly, RH

Start Date: 9/23/2015

Required Date: 9/23/2015

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 13-01-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4471-2P		Purchased	No				Each	0.0000		5			
D4471-2P									**	5x 8015-11-04			
Mid Rib, LH													
M6061T6B1.000X04.00		Purchased	No				f	45.9930		7.473684			
0													
M6061T6B1 000X04 000									**				
6061-T6 Bar 1.00 x 4.00													

Location	Loc Qty	Loc Code
MAT003	45.993	
M126160	9.39	
M127797	1.503	
M128980	0.6	
M129167	34.5	

MS20605-AD3W4 Purchased No

MS20605-AD3W4

Blind Rivet MS 20426 A P 3-4
M131697

Location	Loc Qty	Loc Code
ST308	41	
125654	41	

MS21069L08 Purchased No

MS21069L 08

ANCHOR NUT

Location	Loc Qty	Loc Code
ST301	647	
123522	647	

ml 15/09/29

7.5

20

15/11/23

DAS 30 9-89

NOV 24 2015

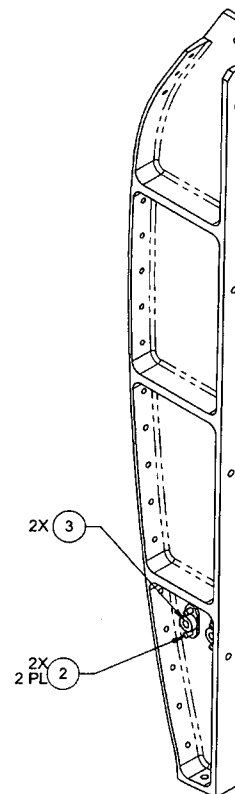
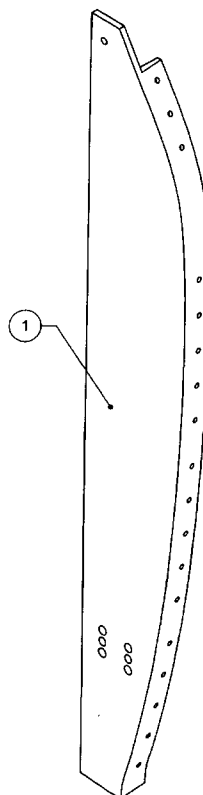
10

DAS 30 9-89

NOV 24 2015

10

ITEM	QTY	P/N	DESCRIPTION
	X	D4471-041	MID RIB ASSY (LH)
1	1	D4471-1	MID RIB (LH)
2	4	MS20605AD3W4	CSK BLIND RIVET
3	2	MS21069L08	NUTPLATE



D4471-041 MID RIB ASSY (LH)

NOTES:

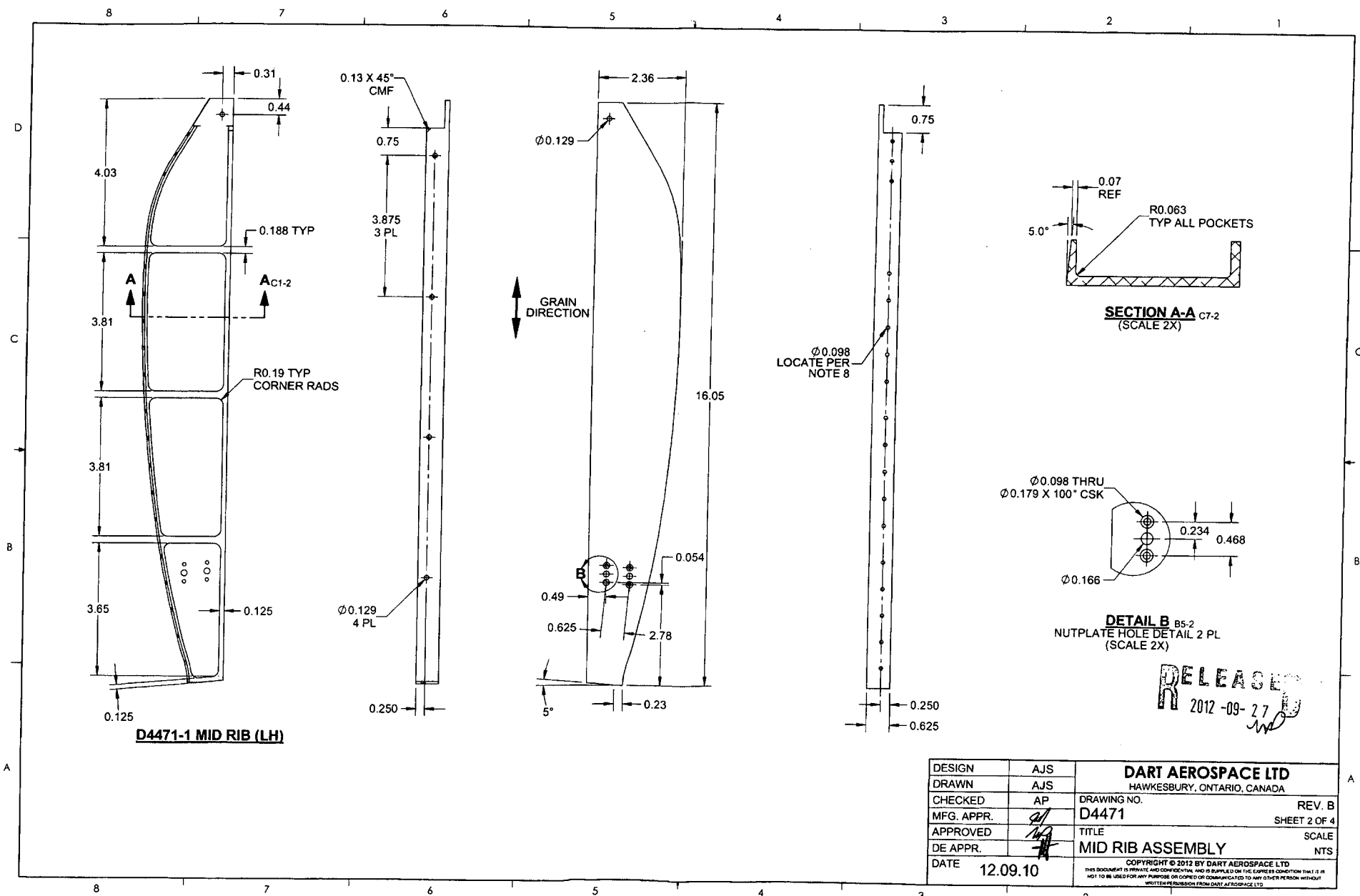
- 1) MATERIAL -1: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
(PRIOR TO HARDWARE INSTALLATION)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.60 lbs
- 8) ALL NON DIMENSIONED FEATURES PER CAD FILE "D4471-1-REVB.STP"
- 9) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL).

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

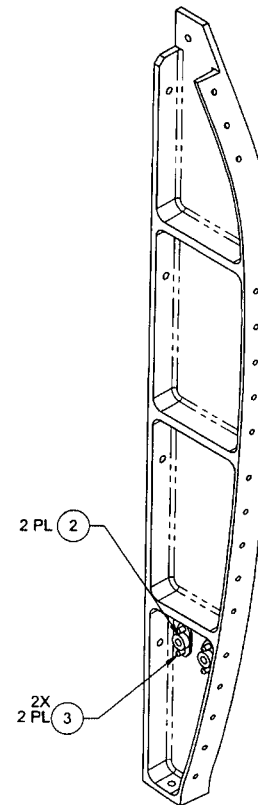
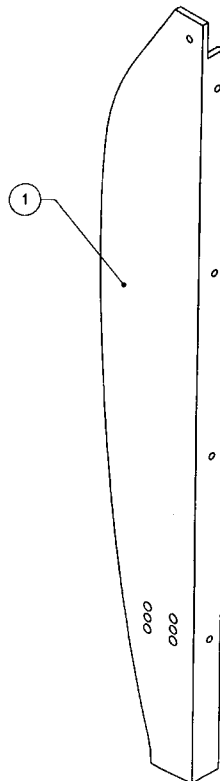
137342 MJS
15-09-25

RELEASED
2012-09-27

B	ADDED -042 & -2 (RH CONFIGURATION), PRIMER NOTE ADDED, NUTPLATE RIVET WAS MS20428AD3-4.	AJS	12.09.10
A	NEW ISSUE	AJS	12.03.05
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4471	SHEET 1 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	MID RIB ASSEMBLY	NTS
DATE	12.09.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ITEM	QTY	P/N	DESCRIPTION
	X	D4471-042	MID RIB ASSY (RH)
1	1	D4471-2	MID RIB (RH)
2	2	MS21069L08	NUTPLATE
3	4	MS20605AD3W4	CSK BLIND RIVET

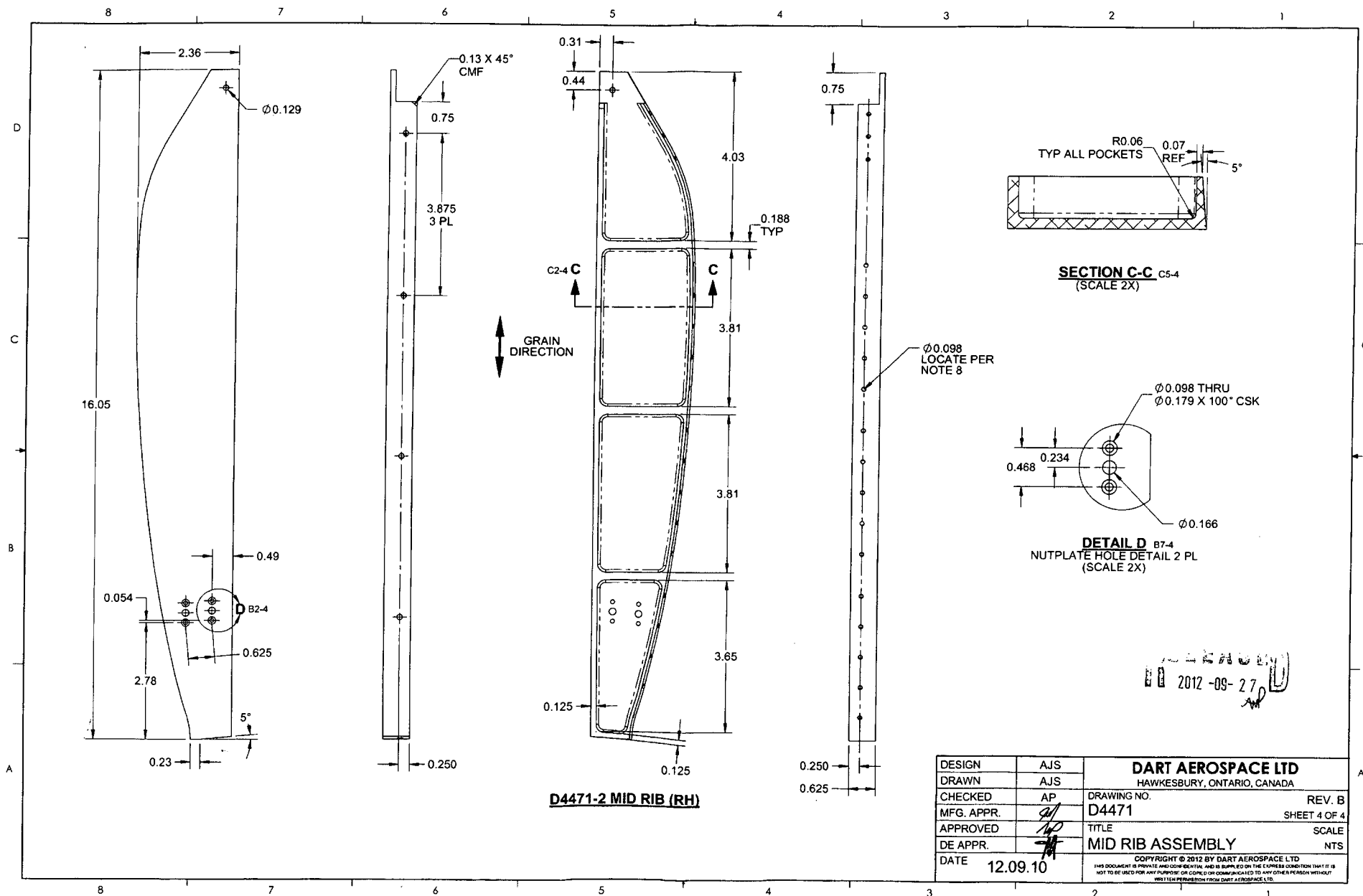


D4471-042 MID RIB ASSY (RH)

NOTES:

- 1) MATERIAL -2: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
(PRIOR TO HARDWARE INSTALLATION)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.60 lbs
- 8) ALL NON DIMENSIONED FEATURES PER CAD FILE "D4471-2-REVB.STP"
- 9) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL).

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4471	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	MID RIB ASSEMBLY	NTS
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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4471	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MID RIB ASSEMBLY	NTS
DATE	12.09.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO29983**

Purchase Order Date 10/2/2015

PO Print Date 10/2/2015

Page Number 1 of 2

Order From :

VC-GLO001

Ship To : DART AEROSPACE LTD

ARCHER PRECISION INC.
2228 GLADWIN CRESENT
OTTAWA, ON K1B 4S6
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 899 2405

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4471-2P MACHINE AS PER DWG D4471 REV. B B137342	Mid Rib, LH	10/20/2015 Yes 10/20/2015		5.00 Each	\$158.33	\$791.65
Line Total:							\$791.65
2	D4472-2P AS PER DWG D4472 REV. B B137224	Fwd Rib, RH	10/20/2015 Yes 10/20/2015		5.00 Each	\$257.25	\$1,286.25
Line Total:							\$1,286.25
3	D4473-2P AS PER DWG D4473 REV. B B137179	Small Rib, RH	10/20/2015 Yes 10/20/2015		5.00 Each	\$85.92	\$429.60

PO Instructions: Fedex Acc#151793240

Note:

10/2/2015



2228 Gladwin Crescent
Ottawa, Ontario
K1B 4S6

Phone # 613-899-2405

Packing Slip

Date	Invoice #
10/30/2015	1783

Ship To

Main Finished Goods Location
Dart Aerospace
1270 Aberdeen Street
Hawksbury, Ontario
K6A 1K7

P.O. No.	Ship	Via	FOB	Project
29983 ✓	10/30/2015	swift	Archer	

Qty	Item Code	Description
5 ✓	Sales	✓ Line item 1 D4471-2P Mid Rib, LH
3 ✓	Sales	✓ Line item 2 D4472-2P Fwd Rib, RH
2 ✓	Sales	✓ Line item 2 D4472-2P Fwd Rib, RH *scrap*
5 ✓	Sales	✓ Line item 3 D4473-2P Small Rib, RH
		HST (ON) on sales
		2015-11-04.

Dart Aerospace

22660

N° DE COMMANDE ORDER NO. P10: 29983		SERV. DEPT.	DATE 15/10/02	
VENDU A SOLD TO		EXPÉDIER A SHIP TO Archer Precision		
ADRESSE ADDRESS		ADRESSE ADDRESS 2228 Gladwin Crescent Ottawa, ont. K1B-4S6		
DATE D'EXPÉDITION SHIPPING DATE	VIA	CONDITIONS TERMS	NO. DE TAXE BY C.O. NO.	VENDU PAR SOLD BY
QUANTITÉ QUANTITY	DESCRIPTION		PRIX PRICE	MONTANT AMOUNT
5 pcs	D4471-2P B137342 mat: 6061T6 BT 1" x 4" B129167		SP15-11-04	
5 pcs	D4472-2P B137224 mat: 6061T6 B 1" x 6" B130013 + B129439			
5 pcs	D4473-2P B137179 mat: 6061T6 B 1" x 2.5"			
Thank Chankel				
SIGNATURE		N° LC. LC. NO.	TPS - GST TVH - HST TVP - PST	TOTAL

FORMULAIRE DE VENTE
SALES ORDER



2228 Gladwin Cres.
Ottawa, Ont.
K1B 4S6

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

2 November 2015

Po Number	Part Number	Quantities
29983	Line item 1 D4471-2P ✓	5 ✓
29983	Line item 2 D4472-2P	3
29983	Line item 3 D4473-2P	5

SP15-11-04

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 29983 issued by Dart Aerospace Inc.

Akos Jagodics
Quality Inspector
Archer Precision Inc.
2228 Gladwin Cress.
Ottawa, Ontario
K1B 4S6



INSPECTION REPORT

Date : 10/27/15



Customer : * u_cus *

Part No.: * u_prtnu *

Plan Name D4472 REVb2

Rev.:

Customer PO.: * u_Cuspo *

BSN :

Incr. Smpl No.: 2

Name	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
Hole 1 Diameter	D	1.24697	1.25000	0.01200	-0.00100	-0.00303	-0.00203
True Position_Hole 1	Po2d	0.00654	0.00000	0.03000		0.00654	-
	X	12.46340	12.46085			0.00255	
	Y	-2.18953	-2.18749			-0.00204	
Hole 2 Diameter	D	0.19852	0.19350	0.00500	-0.00100	0.00502	0.00002
True Position_Hole 2a	Po2d	0.00586	0.00000	0.03000		0.00586	-
	X	10.77915	10.77700			0.00214	
	Y	-0.55449	-0.55249			-0.00200	
True Position_Hole 2b	Po2d	0.00548	0.00000	0.03000		0.00548	-
	X	5.05576	5.05404			0.00172	
	Y	-0.57463	-0.57250			-0.00213	
True Position_Hole 2c	Po2d	0.00624	0.00000	0.03000		0.00624	-
	X	11.30089	11.29891			0.00198	
	Y	-4.26840	-4.26599			-0.00241	
True Position_Hole 2d	Po2d	0.00656	0.00000	0.03000		0.00656	-
	X	3.81224	3.80996			0.00228	
	Y	-3.30474	-3.30238			-0.00236	
Diameter_Hole 3a	D	0.16900	0.16600	0.00500	-0.00100	0.00300	--
True Position_Hole3a	Po2d	0.01789	0.00000	0.03000		0.01789	--
	Z	-0.24122	-0.25000			0.00878	
	X	1.25172	1.25000			0.00172	
True Position_Hole 3b	Po2d	0.01043	0.00000	0.03000		0.01043	--
	Z	-0.24538	-0.25000			0.00462	
	X	7.00241	7.00000			0.00241	
True Position_Hole 3c	Po2d	0.01502	0.00000	0.03000		0.01502	--
	Z	-0.24292	-0.25000			0.00708	
	X	14.00252	14.00000			0.00252	
Hole4 Diameter	D	0.09880	0.09800	0.00400	-0.00110	0.00080	-
True Position_Hole4	Po2d	0.00989	0.00000	0.03000		0.00989	--
	Z	-0.24817	-0.25000			0.00183	
	X	8.62932	8.62472			0.00460	
Diameter_Hole 5	D	0.09892	0.09800	0.00400	-0.00100	0.00092	-
True Position_Hole 5	Po2d	0.01107	0.00000	0.03000		0.01107	--
	Y	-1.50231	-1.49965			-0.00265	
	Z	-0.24514	-0.25000			0.00486	
Diameter_Hole 6	D	0.19465	0.19350	0.00500	-0.00100	0.00115	-
True Position_Hole 6	Po2d	0.00663	0.00000	0.03000		0.00663	-
	X	13.72179	13.71903			0.00276	
	Y	-1.75463	-1.75280			-0.00183	
True Position_Hole6b	Po2d	0.00709	0.00000	0.03000		0.00709	-
	X	13.97399	13.97128			0.00271	
	Y	-3.97291	-3.97063			-0.00228	
Diameter_Hole7a	D	0.13081	0.12850	0.00400	-0.00100	0.00231	--



Name	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
■ True Position_Hole7a	Po2d	0.01077	0.00000	0.01000		0.01077	0.00077
	X	0.44136	0.43958			0.00178	
	Y	-0.43963	-0.43455			-0.00508	
■ True Position_Hole7b	Po2d	0.01094	0.00000	0.01000		0.01094	0.00094
	X	0.81633	0.81458			0.00175	
	Y	-0.50223	-0.49705			-0.00519	
■ True Position_Hole7c	Po2d	0.01052	0.00000	0.01000		0.01052	0.00052
	X	0.44157	0.43958			0.00198	
	Y	-0.93942	-0.93455			-0.00487	
■ True Position_Hole7d	Po2d	0.01101	0.00000	0.01000		0.01101	0.00101
	X	0.81639	0.81458			0.00181	
	Y	-1.12725	-1.12205			-0.00520	
■ True Position_Hole7e	Po2d	0.01113	0.00000	0.01000		0.01113	0.00113
	X	0.44137	0.43958			0.00178	
	Y	-1.43982	-1.43455			-0.00527	
■ True Position_Hole7f	Po2d	0.01140	0.00000	0.01000		0.01140	0.00140
	X	0.81629	0.81458			0.00170	
	Y	-1.75249	-1.74705			-0.00544	
■ Rib 1 Angle	A	65.49709	65.50000	0.50000	-0.50000	-0.00291	-
■ Rib 2 Angle	A	90.00020	90.00000	0.50000	-0.50000	0.00020	-
■ Rib3 Angle	A	97.99877	98.00000	0.50000	-0.50000	-0.00123	-
■ Pocket Depth	Z	-0.49980	-0.50000	0.00500	-0.00500	0.00020	-
■ Curve Form	CurvForm	0.00107	0.00000	0.01000	-0.01000	0.00107	-
■ Curve Form at .350	CurvForm	0.00717	0.00000	0.01000	-0.01000	0.00717	---